V	/nr	k	n	rder	ID	97732	)
71	UL	v.	v	luci	w	71134	-

Page 1

February-21-13 12:42:01 PM D4035-041 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Stop Item Name: Lid Rib Assembly, Fwd (350 Basket) \*1\* Start Qty: 1.00 2/25/13 **Start Date: Cust Item ID:** Required Date: 2/25/13 Req'd Qty: 1.00 **Customer:** Reference: Run Date: 13-62-21 Tooling: Process Plan: MLJ Approvals: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: QC: Operation Tool # Plan Sequence ID/ Set Up/ Tool ID Accept Reject Reject Insp. Qty **Work Center ID** Description Code Qty Number Stamp **Run Hours Draw Nbr Revision Nbr** D4035 Α Weld per dwg A/R S.S. rod Batch: 100 0.00 \*100\* 0.00 Large Fab Memo 1- Cut D4035-1 as per dwg D4035 Large Fab 2- Drill as per dwg D4035 using DT9562 3- remove identification marks and deburr 4- Weld bushing in rib as per dwg D4035 0.00 QC9- Inspect visual per QSI004- Fusion Welds 110 \*110\*

Quality Control

OC

Memo

0.00

r: o				DISPOSITION							· · · · · · · · · · · · · · · · · · ·
ö				_	,			AGAINST DEI	PARTMENT/	PROCESS  Water Jet	
Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Composite						Engineering Quality Other	
Date	Step	Otv		•	1	i			Sign & Date	Verification	QC Inspector
					AUL	T CATE	ORY				
Centre Cracks Crushe Cuffs Heat T Inspec Ripple	Not Conce d/Crimped reat tion Strip in s in Bend	n Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instructi Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/Un nance ed		Part Incorred Part Lost/Mi Part Moved Positioned V	ssing Vrong	Pressure/Fórced Temperature/Cure Weld Wrong Stock Pulled
	g Gear Bendin Centre Cracks Crushe Cuffs Heat Ti Inspect Ripples	p Gear Bending Centre Not Conce Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend	Date Step Qty  Bending Centre Not Concentric to Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	Description Descri	Date Step Qty Description of work order update or Non-conformance  F. General  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend  Description of work order update or Non-conformance  F. General Bend BoM/Route Broken/Damaged Burrs Countersink Cut Too Short Drill Holes	Date Step Qty Description of work order update or Non-conformance Chamber Step Qty Or Non-conformance	Date Step Qty Description of work order update Chief Eng  FAULT CATEO  Georgia Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Crushed/Crimped. Crushed/Crimped. Burrs Instruction Cuffs Contamination Maintee Heat Treat Countersink Mislabel Inspection Strip in Tube Ripples in Bend Drill Holes Offset	Step Qty Description of work order update Date Step Qty Or Non-conformance Description of work order update Description of work order update Or Non-conformance O	Use-as-is Work Order Update	Use-as-is Work Order Update	Use-as-is Work Order Update

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence
Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97732	Work	Orde	r ID	97732
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\*97732\*

Page 2

ebruary-21-1.	3 12:42:01 PI	<u> </u>									
tem ID: Revision ID:	D4035-041			Accept	*N900	040	100	)* s	etup Start	*N	S1*
tem Name:	Lid Rib Asser	mbly, Fwd (350 Basket)							Stop	*N.	S2*
Start Date: Required Date Reference:	2/25/13 e: 2/25/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Tooling:	D:	ate:		R	un Start	*N	R1*
ippi ovais.						ate:			Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp
120		QC5- Inspect part compl	leteness to step on W/O	0.00				_			· • • • • • • • • • • • • • • • • • • •
*120* QC Quality Control		Memo		0.00				<u>_</u> @	13-05.	93	- 09 09 09
Quanty Connec							,				
130	,	Identify as per dwg & St	ock Location:	0.00				1,	13.0		
*130* Packaging Packaging		Memo		0.00					13.0	5.24	
140		QC21- Final Inspection	- Work Order Release	0.00					ml	//a-	7 H
*140* <sup>QC</sup>		Memo		0.00					1.//	/	177)
Quality Control										· //	23
										1/	7 -

					,					*		DQA:	Dat	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE			_		
···				**		) }		<u> </u>			QA Closed: Date:			e:	
Work Ord	er.					DISPOSITION				AGAINST D	EF	PARTMENT/	PROCESS		
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root					Descri	ption of work order update	-1	nitial	Act	ion	Ţ	Sign &			
Cause		Date	Step	. Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u> </u>	QC Inspector
Doc/Data								-							
Equip/Tooling															
Operator															
Material			į												
Setup															
Other															
Process	Ш			1 17											
Supplier					·						١				!
Training	Ш										-				, <b>*</b>
Unapproved										<u></u>	┙				· 
-							AUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·	_	· · · · · · · · · · · · · · · · · · ·			
Landi			•		٠,	General		1		_	_		· [		1
	$\vdash$	Bending				Bend	<u> </u>	Grain			-	Ovalized			Pressure/Forced
	Ш	Bending Centre Not Concentric to O/S				BOM/Route	<u> </u>	Hardwa		ļ	1	Over/Under	}		Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged	$ldsymbol{ld}}}}}}$	1 '	on Incomplete	·	⊣	Part Incorred	<b>.</b>		Weld
	Ц	Crushed/	Crimped.	-		Burrs	<u></u>	4	ions Incomplete/l	Jnclear		Part Lost/Mi	ssing		Wrong Stock Pulled
!	LJ'	Cuffs				Contamination		Mainte		1		Part Moved			
		Heat Trea	t			Countersink		Mislabe	eled			Positioned V	/rong		1
	I li	nenaction	n Strin in	Tube	[	Cut Too Short	i	Misread	1	1	- 1	Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work Order ID:

97732

Parent Item:

D4035-041

Parent Item Name:

Lid Rib Assembly, Fwd (350 Basket)

**Start Date: 2/25/13** 

Required Date: 2/25/13

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP RevA: new issue DD 09.11.25 verified by:EC

verified by:EC

IPP Rev:B as per dwg revA 10.03.15

	verified by:EC												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	69.0000	1	1	`		
Spacer Bushing									<b>B</b> 9	8 701:	- HX		<u> </u>
÷.				Location		Loc Qty	Lo	oc Code			O,	113.	1
				WA004		69					S	13.	05
				755	64	1							)
•				772		1							1
				811		2				<del></del>			į
				869		5							1
				893		40 20							1
<b>M304TS0.750W.049</b> 304 SQ Tube .75x.75x.049	W	Purchased	No	896	J <del>4</del>	100	f	1,013.2474	1.75	1.84210:	53	ly is	3 OS
`				Location		Loc Qty	Lo	oc Code	MI	2557	3		:
				MAT017		566.3158							
				124	492	566.3158							
				WA006		446.9315594							
				123	219	64.5285735							
				123	484	382.402986							

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	CONF	ORN	AANCE / UP		OA Clasadi	Data	
				·						QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Order.		****		·	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-				Use-as-is	]   7	herm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No.					Work Order Update	]		Large Fab	Composite		Supplier	
											·	
Root				Descri	ption of work order update	Init	ial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		-				1			-			3
Equip/Tooling			].									
Operator												
Material		Ī										
Setup	]											
Other										:		
Process												
Supplier						i						
Training						ļ					Į.	
Unapproved				<u> </u>		<u> </u>		L	· · · · · · · · · · · · · · · · · · ·	<u></u>		
-						AULT (	CATE	GORY				
Landing (	7				General					1	Γ-	1_ /
1	Rending			- 1	Bend	I IG	rain		1	Ovalized	1	Pressure/Forced

Hardware

Misread

Offset

Maintenance Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

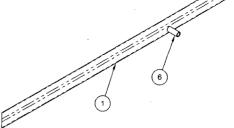
Finish Folio

Broken/Damaged

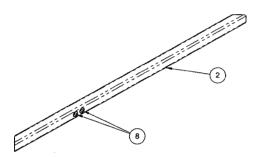
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			Х	_	D4035-045	LID RIB ASSY, FWD (LIGHT)
				Х	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		111			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

SHOP COLAS R' TRN IO ENGINE FRING UNCONTROLLED COPY SUBJECT TO ALTENDMENT WITHOUT NOTICE WORK CROTER NO. 97732MC

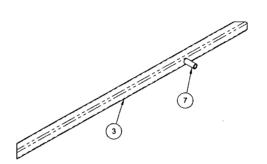
13-02-21



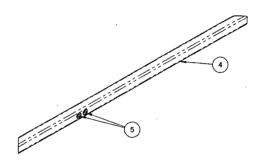
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)** 



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)** 



Α	NEW IS	SUE		JPH	10.03.04			
REV.			DESCRIPTION	BY	DATE			
DESIG	V	AJS	DART AEROSP	ACE L	TD			
DRAW	V.	JPH	HAWKESBURY, ONTAF					
CHECK	ŒD	la la	DRAWING NO.		REV. A			
MFG. A	PPR.	A	D4035		SHEET 1 OF 5			
APPRO	VED	W	TITLE		SCALE			
DE APP	PR.	-44	BASKET LID RIB AS:	SY	NTS			
DATE	10.0	3.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS OCCUMENT IS PROVITE AND COMPRETING, AND IS SEPTILED ON THE EMPLIES CONCITON THAT IND TO BE SECTION AFF PLANDES OF COMPLETON CONCENSIONATED TO ANY THEFE PRIOR WHITE AND WHITE AREA WITH THE PROPERTY OF COMPANY AND ANY THE PROPERTY OF COMPANY ANY THE PROPERTY OF COMPANY AND ANY THE PROPERTY OF COMPANY.					

